

Work Order ID 61413

August 24, 2010 10:11:25 AM



Page 1

Item ID: D119-696-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Dual Cargo Mirror Assy

Start Date: 8/24/10 Start Qty: 10.00



Cust Item ID:

Required Date: 9/07/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 10/8/24 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3074	A2 U/R	<u>10.0825</u>				<u>10.08</u>			
100	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1- punch one side 2- slide parts in tube 3- punch other side 4- bend as per dwg D3074 5- drill holes as per dwg D3074 6- deburr and polish								
110	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

=> M.H 10/09/08

8/10/09/08

110

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	Small Fab	0.00							
Small Fab	Memo	0.00				(10X)			
Small Fab	Assemble as per dwg D3074								
130 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00				(410)			
Quality Control									
140 	Identify as per dwg & Stock Location: RPP	0.00							
Packaging	Memo	0.00							
Packaging									

⇒ m.k 10/09/08

Solo 10/09/08

Per 10/9/14 (10)

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/14 *[Signature]*
[Signature]
10-9-14

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Picklist Print

August 24, 2010 10:11:25 AM

Page 1

Work Order ID: 61413

Parent Item: D119-696-043

Parent Item Name: Dual Cargo Mirror Assy



Start Date: 8/24/10

Required Date: 9/07/10

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 08-02-19 New issue DD verified by: LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD10 Washer	NAS1149D0363J	Purchased	No				Each	6.0000	6	60			
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				ST	6								
					107715								
D2011-101 6" Mirror		Manufactured	No				Each	9.0000	2	20			
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				ST228	2								
					61275								
				ST231	7								
					58398								
D2054 Bushing		Manufactured	No				Each	38.0000	2	20			
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				ST005	38								
					56291								
					58392								
D2055 Clamp		Manufactured	No				Each	44.0000	2	20			
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				ST005	44								
					55726								
					58393								

M-L 10/09/01

60X

M-L 10/09/01

13X
2X

7X

M-L 10/09/01

20

M-L 10/09/01

20

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Page 2

August 24, 2010 10:11:25 AM

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Parent Item: D119-696-043

Parent Item Name: Dual Cargo Mirror Assy

Start Date: 8/24/10

Required Date: 9/07/10

Start Qty: 10.00

Required Qty: 10.00

D2056 Manufactured No Each 15.0000 1 10
Bell Crank

Location	Loc Qty	Loc Code
ST006	15	
45542	13	
58514	2	

m-l 10/09/01

D3072-1 Manufactured No Each 13.0000 1 10
Bracket

Location	Loc Qty	Loc Code
ST035	13	
53119	1	
57252	12	

m-l 10/09/01

D3072-2 Manufactured No Each 11.0000 1 10
Bracket

Location	Loc Qty	Loc Code
ST035	11	
57253	11	

m-l 10/09/01

M304TR0.500W.049 Purchased No f 248.8119 3.49 36.73684
304 RD Tube .500 x .049W

Location	Loc Qty	Loc Code
MAT 14676	232.9789478	
115010	32.9789478	
MAT 117	15.833	
111814	15.833	

20.94 m-l
3.49
10.47
10/08/31

(3x) M 114045 ✓

August 24, 2010 10:11:25 AM

Shop Packet Print

Page 2

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Page 3

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Parent Item Name: Dual Cargo Mirror Assy

Start Date: 8/24/10

Required Date: 9/07/10

Start Qty: 10.00

Required Qty: 10.00

MS21042L3
Nut
Purchased No



Each 2,311.000 3 30



m.l 10/09/08

Location

Loc Qty

Loc Code

ST300

2311

114523

115

114718

196

114784 ✓

2000

MS27039-1-18
Screw
Purchased No



Each 69.0000 3 30



30X

m.l 10/09/08

Location

Loc Qty

Loc Code

ST292

69

113845 ✓

69

30X

August 24, 2010 10:11:25 AM

Shop Packet Print

Page 3

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**DART**

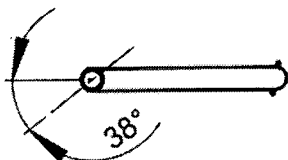
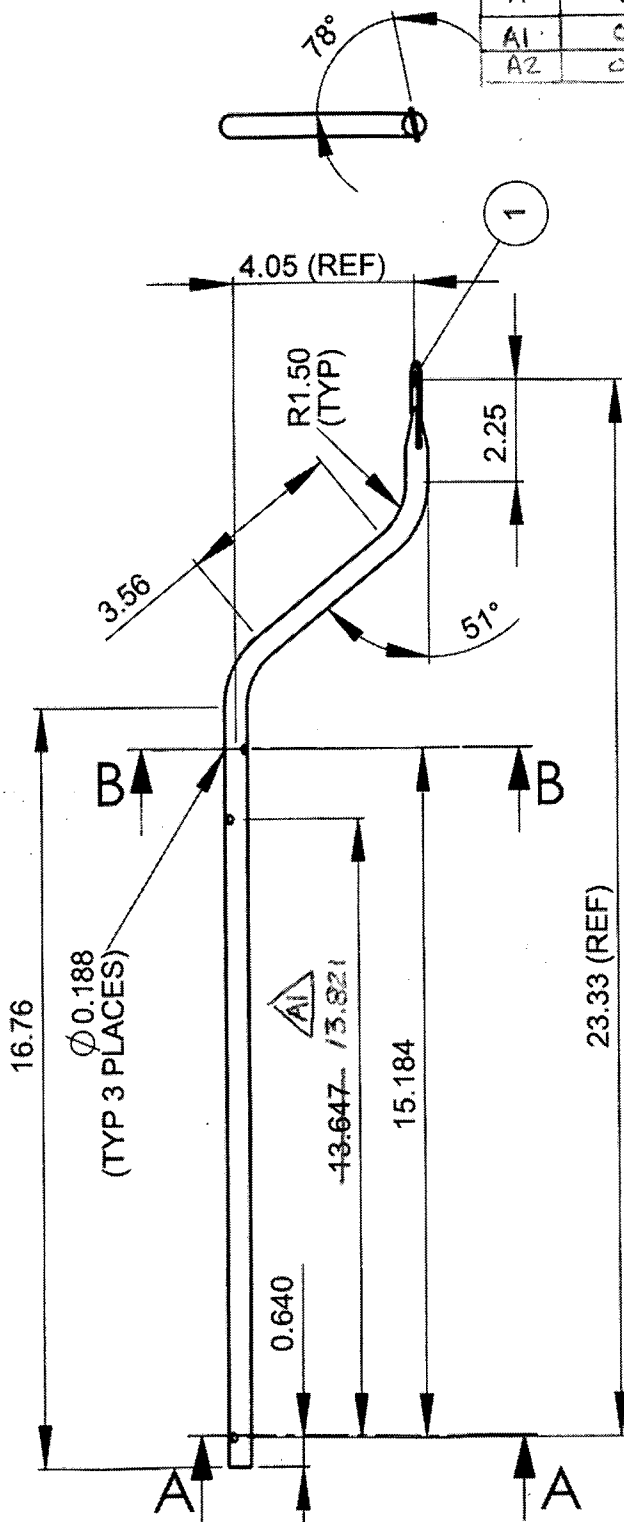
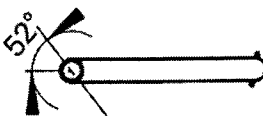
DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D3074 REV. A SHEET 1 OF 2
DATE	01.12.17	TITLE	ARM	SCALE 1:4
A	01.12.17	NEW ISSUE		
A1	02.01.15	13.821 WAS 13.647	CP	
A2	02.03.22	ADD FINISH	CP	

UNDER REVIEW

03.06.23 *1st*
CHANGE TO 0.049"
WALL THICKNESS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60443
C8108/24

*all
BOM
changed*

SECTION B-B
(1 PLACE)SECTION A-A
(TYP 2 PLACES)**RELEASED**
02.01.15**D3074-1**

- 1) PUNCH END PER SPEC CONTROL DRAWING D2727
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE, $\phi 0.50 \times 0.035$ WALL
ENSURE SEAMLESS TUBING IS USED
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) FINISH: POWDER COAT BLACK SANDTEX (4.35.7) PER DART QSI 005 4.3 / A2

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

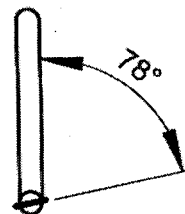
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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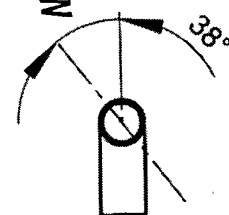
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. A
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	
DATE	TITLE	DRAWING NO.	SHEET 2 OF 2
01.12.17	ARM	D3074	SCALE 1:4



RELEASED
02.01.15

UNDER REVIEW



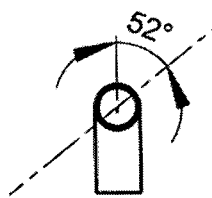
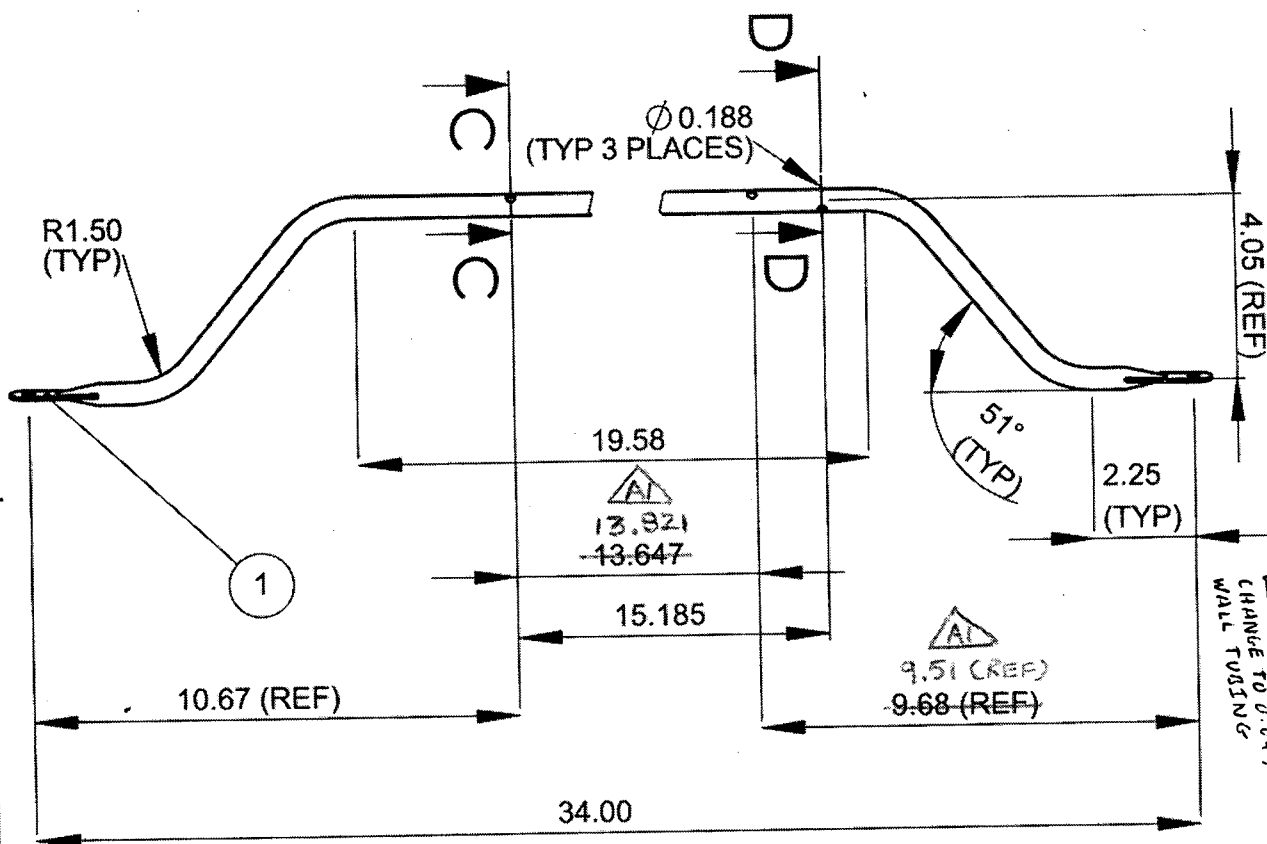
03.06.13
CHANGE TO 0.049" WALL THICKING

SHOP COPY

SECTION C-C (1:2)
(TYP 2 PLACES)

SECTION D-D (1:2)
(1 PLACE)

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 61413



D3074-3

- 1) PUNCH ENDS PER SPEC CONTROL DRAWING D2727
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE, $\phi 0.50 \times 0.035$ WALL
ENSURE SEAMLESS TUBING IS USED
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS NOT SYMMETRIC

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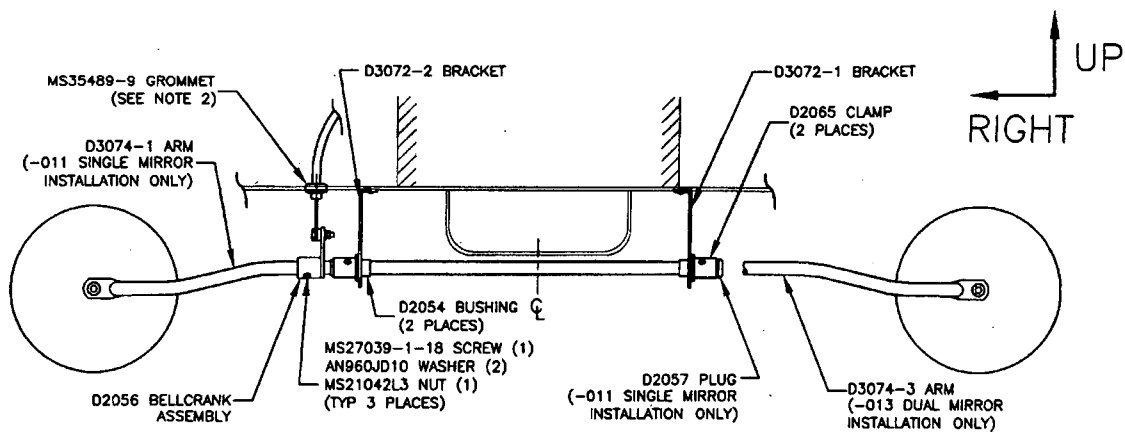


Figure 25-2 – View A: Looking Aft
(D119-696-011/-013 Mirror Shown)

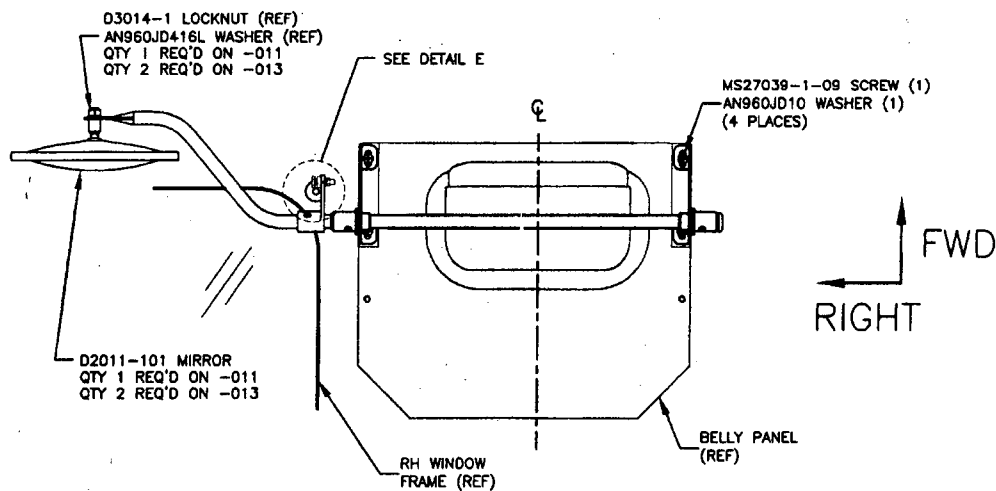


Figure 25-3 – View B: Looking Up
(D119-696-011 Mirror Shown, -013 similar)

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Dart Aerospace Ltd

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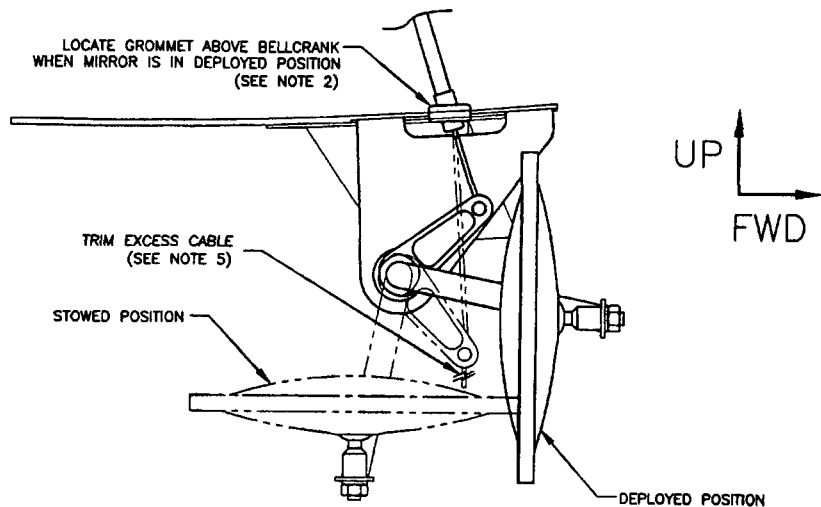


Figure 25-4 – Detail C: Side View of Mirror Deployment
(D119-696-011/-013 Mirror Shown)

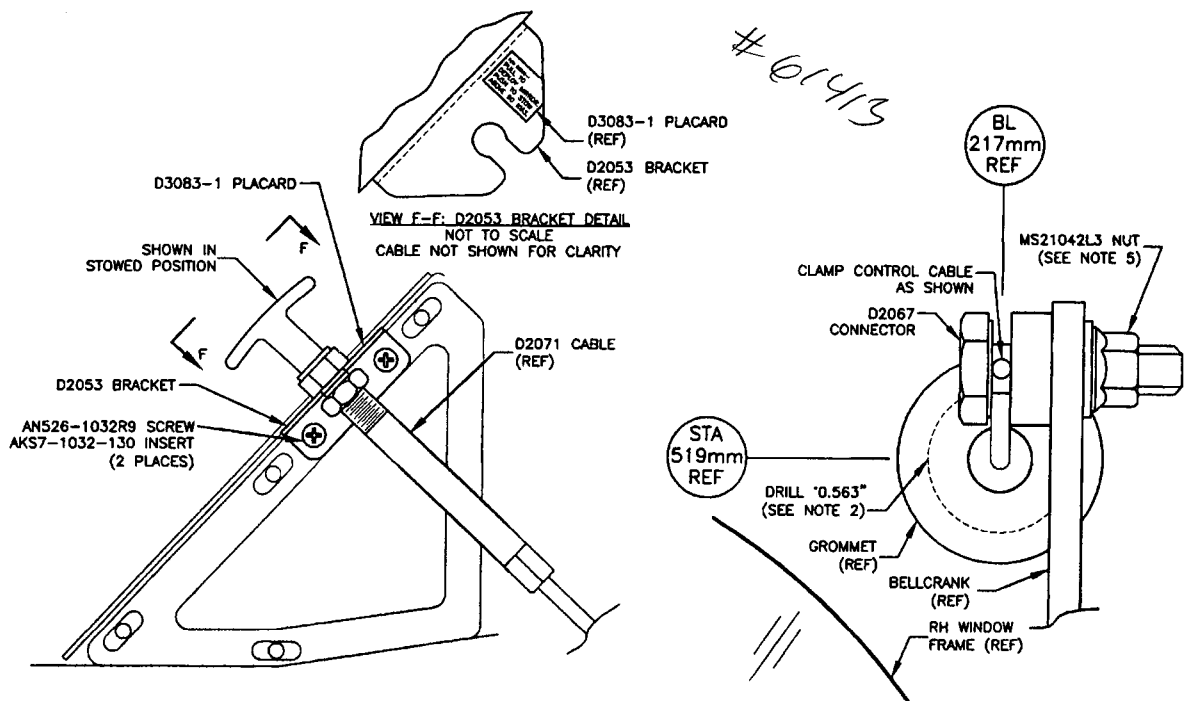


Figure 25-5 – Detail D
Control Panel Attachment
(D119-696-011/-013 Mirror Shown)

Figure 25-6 – Detail E
Bellcrank/Cable Attachment
(D119-696-011/-013 Mirror Shown)

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